

Dart Aerospace Ltd.

Date: Tuesday, 17/04/2007 11:01:38 AM  
User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-540-013  
 Job Number : 31879  
 Estimate Number : 10804  
 P.O. Number : *N/A* Part Number : D206540013  
 This Issue : 17/04/2007 S.O. No. : *N/A* Drawing Number : RTN 581  
 Prsht Rev. : NC Project Number : *N/A*  
 First Issue : 17/04/2007 Type : LARGE FAB ASSY Drawing Revision : *N/A*  
 Previous Run : 00015 Material : *N/A* Due Date : 24/04/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment :

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 QC5 INSPECT WORK TO CURRENT STEP

*20704.17 (1)*

Comment: INSPECT RTN 581

2.0 D206540013 Heli Utility Basket (B)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Heli Utility Basket (B)

ORIGINAL B/N 22087

3.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1  
PICK FOLLOWING ADD TO KIT:

4 X D3396-3 B *24583* (PER DSI 9361) ✓  
 2 X AN4-12 B *7128* ✓  
 7 X AN960JD416 B *M102929* ✓

*7/4/17 SG*

4.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 REPACKAGE PER PPP - CHG 005  
 USING NEW B/N  
 NEW LABELS & PAPERWORK (INCLUDING DSI9361)

<b>DART</b>				TEL.: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-89				FAX: 1-613-632-4443	
P/N	D206-540-013	CHG	CHG004		
DESC.	Heli-Utility-Basket	STC	SH94-5		
LOT	B22087	STC	SR00386NY		
MODEL	206A/B	STC			
MADE IN CANADA					

Date: Tuesday, 12/20/2005 9:44:18 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206B UTILITY BASKET
<b>Job Number</b>	: 22087		
<b>Estimate Number</b>	: 11282		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D206540013
<b>This Issue</b>	: 12/20/2005	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: UNDER REVIEW
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: N/A	<b>Drawing Revision</b>	: 1
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	: N/A
<b>Written By</b>	: SEE COMMENT BELOW	<b>Due Date</b>	: 1/30/2006
<b>Checked &amp; Approved By</b>	: SEE ABOVE USER & DATE	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:1 Revised as per Rev 1 05-12-07 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD206-540-013 CHG004

Dtt 06/04/07 (1)

2.0	22087A	206B BASKET LID
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Comment: Sub-Component 206B BASKET LID

3.0	22087B	206B BASKET BASE
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Comment: Sub-Component 206B BASKET BASE

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B25136

6.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B23396

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

825825 ✓

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

819424 ✓

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

824826 ✓

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper

821139 ✓

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet

113767 ✓

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A

Bolt

118369 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt M17204 ✓

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt M19413 ✓

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt M18822 ✓

16.0

AN517A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

6 AN5-17A

Bolt M19551 ✓

17.0

AN960JD416

Washer



Comment: Qty.: ~~4.0000~~ Each(s)/Unit Total : ~~4.0000~~ Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD416

Washer M100375 ✓

2.000 Each (G)

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

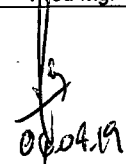
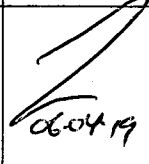
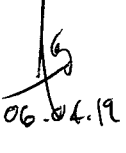
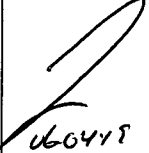
Qty Part Number


Description Batch

4 AN960JD516

Washer M19185 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.04.19	17.1	2x AN960SD4116 L washers req'd for Prop Num Assy. B# <u>M 100229</u>  Add to I.P.D. : dwg - Permanent change	SAD	06.04.19	1			
06.04.19	23.1	Placard should be a D2851-170, and installed during Ass'y. Install D2851-170 to lch. B# <u>21514</u>  Permanent change	SAD	06.04.19	1			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/04/20  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M100150 /

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD8

Washer

M11729 /

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M18917 /

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M19099 /

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M19073 /

SAD

06:04:15

①



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Tuesday, 12/20/2005 9:44:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D206-540

*Sub 06.04.15 (1)*

25.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*06.04.19*

26.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Pick: Packing Kit

27.0	D2249041	Fitting Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick: Packing Kit  
2 D2249-041 Braket *B23776 ✓*

28.0	D2022101	Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick: Packing Kit  
4 D2022-101 Spacer *B23396 ✓*

29.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick: Packing Kit  
1 D2012-107 Clevis *B25483 ✓*

<del>30.0</del>	<del>D2258170</del>	<del>Placard - 170 lb</del>
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:

Qty	Part Number	Description	Batch
1	D2258-170	Placard	<i>B25114</i>

*See P10 for step 23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	D2259	Label
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

B10671 ✓

32.0	D2525	Spacer Kit
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B12105 ✓

33.0	D2526	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

B17519 ✓

34.0	D2748	Clevis
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

1x B15196 - 1x B23416

35.0	D27491	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

B23423 ✓

36.0	D27493	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

B23424 ✓

37.0	D2814	Strut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B25296 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M100273 ✓

39.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12

Bolt

M7188 ✓

40.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A

Bolt

M100089 ✓

41.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A

Bolt

M19551V

42.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A

Bolt

M295 ✓

43.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

19 AN960JD416

Washer

M100575 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

M19185 ✓

45.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

M100151 ✓

46.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

M19099 ✓

47.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

M19073 ✓

48.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

M3355 ✓

49.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

M9599 ✓



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 22087

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

AN3204

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

m7128 ✓

51.0

AN38022

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

m716895 ✓

AS 06/04/19 ①

52.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 6/4/19 ①

53.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location: \_\_\_\_\_

PPP Rev: G

AS 06/04/19 ①

54.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AS 06/04/20 ①

Job Completion



h 06-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

5/04

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22087</b>
<b>Description:</b> 206B Utility Basket Inst'n	<b>Part Number:</b>	<b>D206-540-013</b>
<b>Drawing:</b> D206-540 Rev. H Pages 1,5, 6 & 8	<b>Qty:</b>	<b>1</b>
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty																																																																																																																																																																																				
1	DC	Issue Travellers for: D206-540-013    Utily Basket    Inst'l'n D2330-041        Base D2330-043        Lid <div>Batch 22087 22087 22087</div>	RF	04.12.14	1																																																																																																																																																																																				
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RELEASED  
10/05/16 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22087</b>
<b>Description:</b> 206B Utility Basket Instl'n	<b>Part Number:</b>	<b>D206-540-013</b>
<b>Drawing:</b> D206-540 Rev. H Pages 1,5, 6 & 8	<b>Qty:</b>	<b>1</b>
		<b>Page 2 of 2</b>

5	GA	Assemble as per Dwg D206-540 Attach Travellers: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>1</td><td>D2330-041</td><td>Base</td><td>_____</td></tr><tr><td>1</td><td>D2330-043</td><td>Lid</td><td>_____</td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D2330-041	Base	_____	1	D2330-043	Lid	_____			
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1	D2330-041	Base	_____														
1	D2330-043	Lid	_____														
6	QC5	Inspect for foreign object per QSI 024 & Assembly work to Step 5															
7	QC4	Inspect 100% kit for completeness															
8	PK	Box and identify as per PPP D206-540-013															
9	AC	Cost / part:															
10	DC	Close Work Order and Ensure Travellers Attached Inspect Level 21 Travellers: D206-540-013 D2330-041 D2330-043															

Rev	Date	Change	Revised By	Approved
A	94.12.03			JB
B	99.10.07	Re-format	EC	
C	99.12.01	Changed pick list (MPP 1001 and CAR 105)	EC	
D	00.04.12	Changed dwg revision	EC	
E	00.07.21	Added inspection for QSI 024	EC	
F	00.09.12	Reduced qty for bumper (TSR 1303)	EC	
G	02.07.24	Re-form Location; Modify Step 1,5	KJ	
H	02.08.15	Added D2749-1	KJ RF	QA

**RELEASED**  
02/05/16 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Dec 13, 2004  
11:38 am

Work Order No	: 0022087	Department Code:	
Project Name	: D206-540-013	Burden Flags	: NNNNNNNN
Project For	: WK504	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D206-540-013	Invoice Number	:
Description	: Heli Utility Basket (B)	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 12-10-04		
Est Finish Date	: 01-28-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



PART AEROSPACE LTD		Work Order: 22087
Description: 206B Utility basket	Part Number: 0206-540-013	
Dwg: 0206-540 Rev. H	Qty: 1	Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller			
2	GA	remove rivets and hinge from the lid and base. Scrap hinge, remove hardware	J	05.06.07	1
3	GA	remove powdercoat from hinge locations on basket base and lid.	J	05.06.07	1
4	GA	drill a $\frac{3}{8}$ " hole in the end corner of the base and lid to remove foreign objects	J	05.06.07	1
5	GA	Mark out original hole pattern on the base and lid clearly on the edge using tape (DO NOT PUT PEN or marker on powdercoat)	J	05.06.07	1
6	QC 5	Inspect	J	05/06/07	1
7	WS	Fill in holes with weld rod b# M16781	J	05/06/07	1
8	WS	Grind welds flush	J	05/06/07	1
9	QC 9	Inspect weld.	J	05.06.07	1
10	FP	Powder coat AS per RS1004	J	05.06.08	1
11	QC 3	Inspect Powder Coat.	J	05.06.08	1
12	GA	drill hinge AS per dwg 0206-540	J	05.06.09	1
13	GA	locate hinge on basket opposite of original holes.	J	05.06.09	1

Rev	Date	Change	Revised By	Approved
1		New issue	JM	J 05.06.07
14	GA	re-Assemble basket AS per dwg 0206-540	J	05.06.09
15	QC 5	Inspect work to Step 14	J	05.06.09

5/10/9

5/04

DUPLICATE

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22087</b>
<b>Description:</b> 206B Utility Basket Instl'n	<b>Part Number:</b>	<b>D206-540-013</b>
<b>Drawing:</b> D206-540 Rev. H Pages 1,5, 6 & 8	<b>Qty:</b>	<b>1</b>
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travellers for: D206-540-013 Utility Basket Instl'n D2330-041 Base D2330-043 Lid		05.05.24	1
2	DC	Photocopy blue file and type labels per PPP D206-540-013 WK <del>CHG-002</del> CHG 003 RF 02/09/03 Dwg. not required			
3	WS	Go to Traveller D2330-041; D2330-043		05/05/31	1
4	KP	<b>Pick: Ass'y Kit</b> Qty Part Number Description Batch 1 D2258-170 Placard B21514 ✓ 1 D2332-041 Prop Ass'y B22850 1 D2530 Handle weldment B22116 1 D2537 Bushing B22785 1 D2569 Hinge B21507 ✓ 1 D2535 Spring B22760 1 D2931 Bumper B21139 ✓ 1 AD64ABS Rivet M16915 ✓ 1 MS20600AD4W3 Rivet M11660 ✓ 1 AN3-16A Bolt M14820 ✓ 1 AN4-22A Bolt M15387 ✓ 1 AN5-17A Bolt M16273 ✓ 1 AN960JD416L Washer M3154 ✓ 1 AN960JD516 Washer M16527 ✓ 1 AN970-4 Washer M16895 ✓ 1 MS21042L3 Nut M15924 ✓ 1 MS21042L4 Nut M15924 ✓ 1 MS21042L5 Nut M16822 ✓ 1 AN960JD8 Washer M16096 ✓		05-06-03	1
		<b>Pick: Packing Kit</b> 2 D2249-041 Bracket B20834 4 D2022-101 Spacer B21505 1 D2012-107 Clevis B23037 1 D2259 Placard B10671 2 D2525 Spacer kit B17847 2 D2526 Bushing B17519 2 D2748 Clevis B15196 1 D2749-1 Strut B11012 1 D2749-3 Strut B11013 2 D2814 Strut B19552 2 AN4-12A Bolt M16323 2 AN4-12 Bolt M17188 8 AN4-5A Bolt M15247 2 AN5-17A Bolt M16273 2 AN4-21A Bolt M2951 1 AN960JD416 Washer M16941 2 AN960JD516 Washer M10765 1 AN970-4 Washer M16895 4 MS21042L4 Nut M15924 2 MS21042L5 Nut M16822 1 MS27039-4-11 Screw M3355 1 AN4-6 Bolt M9599 M16067 3 AN320-4 Nut M7188 3 AN380-2-2 Cotter pin M342 2 D2852 Placard B21515		05-06-09	1

RELEASED  
02/05/16 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22087</b>
<b>Description:</b> 206B Utility Basket Inst'n	<b>Part Number:</b>	<b>D206-540-013</b>
<b>Drawing:</b> D206-540 Rev. H Pages 1,5, 6 & 8	<b>Qty:</b>	<b>1</b>
		<b>Page 2 of 2</b>

5	GA	Assemble as per Dwg D206-540 Attach Travellers: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2330-041</td><td>Base</td><td>B22087</td></tr><tr><td>1</td><td>D2330-043</td><td>Lid</td><td>B22087</td></tr></table>	Qty	Part Number	Description	Batch	1	D2330-041	Base	B22087	1	D2330-043	Lid	B22087	ml	05-06-06	1
Qty	Part Number	Description	Batch														
1	D2330-041	Base	B22087														
1	D2330-043	Lid	B22087														
6	QC5	Inspect for foreign object per QSI 024 & Assembly work to Step 5		ml	05-06-09	1											
7	QC4	Inspect 100% kit for completeness		ml	05-06-09	1											
8	PK	Box and identify as per PPP D206-540-013	REV. H	ml	05-06-06	1											
9	AC	Cost / part: 1804.33		ml	05-06-09	1											
10	DC	Close Work Order and Ensure Travellers Attached Inspect Level 21 Travellers: D206-540-013 D2330-041 D2330-043		ml	05-06-14	1											

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H	02.08.15	Added D2749-1	KJ RF	QA

**RELEASED**  
02/05/16 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <b>KE</b>	DRAWN BY <b>CP</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>X</b>	APPROVED <b>X</b>	DRAWING NO. D206-540	REV. H SHEET 1 OF 8
DATE 99.12.02		TITLE UTILITY BASKET INSTALLATION	SCALE NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	

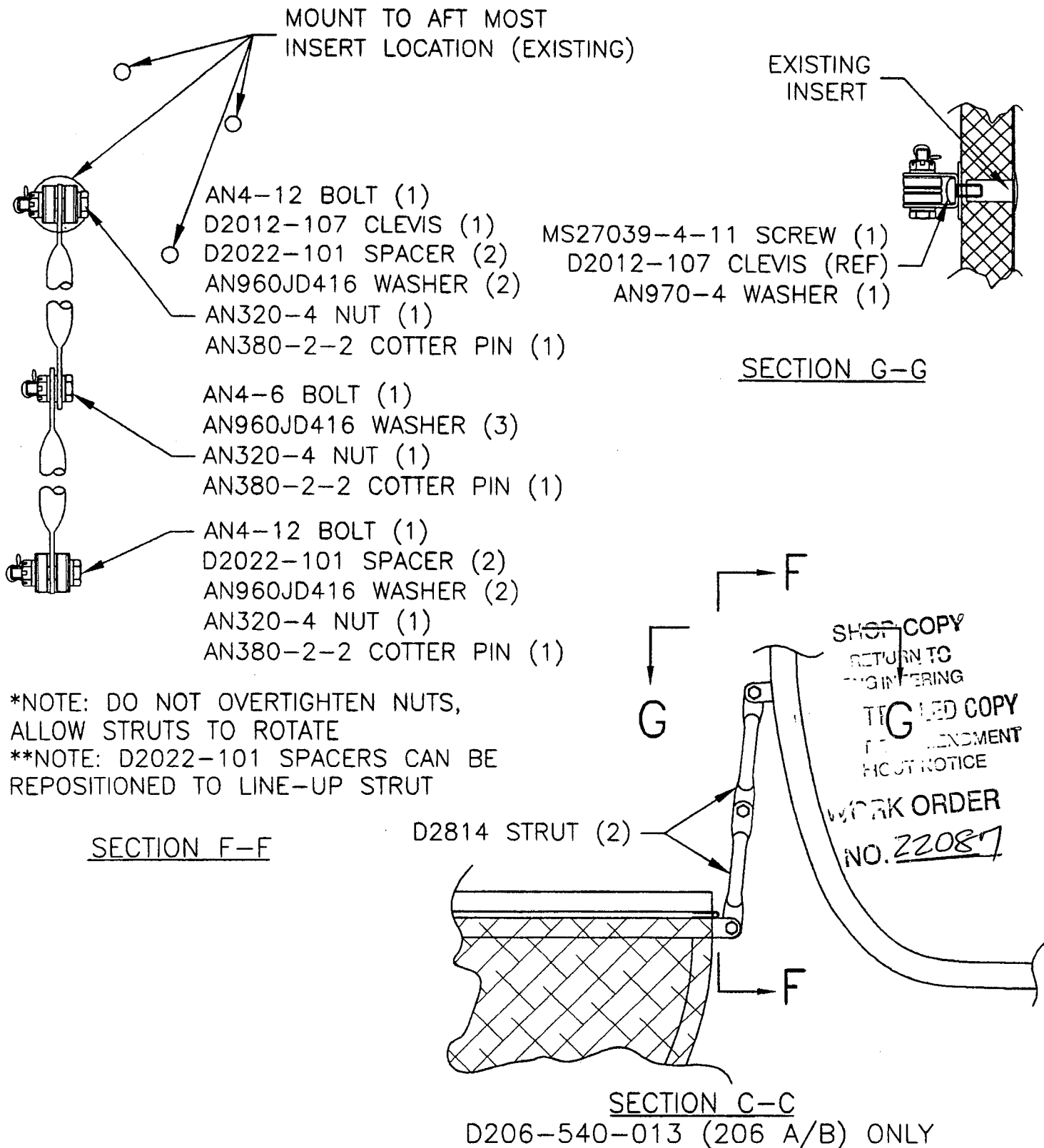
Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
	4	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
1	1	D2569	HINGE
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
38	38	AD64ABS	RIVET
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
2	2	AN4-22A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
6	6	AN5-17A	BOLT
14	21	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
6	6	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

\*NOTE: Placard D2259 to be installed in cockpit near the airspeed indicator.

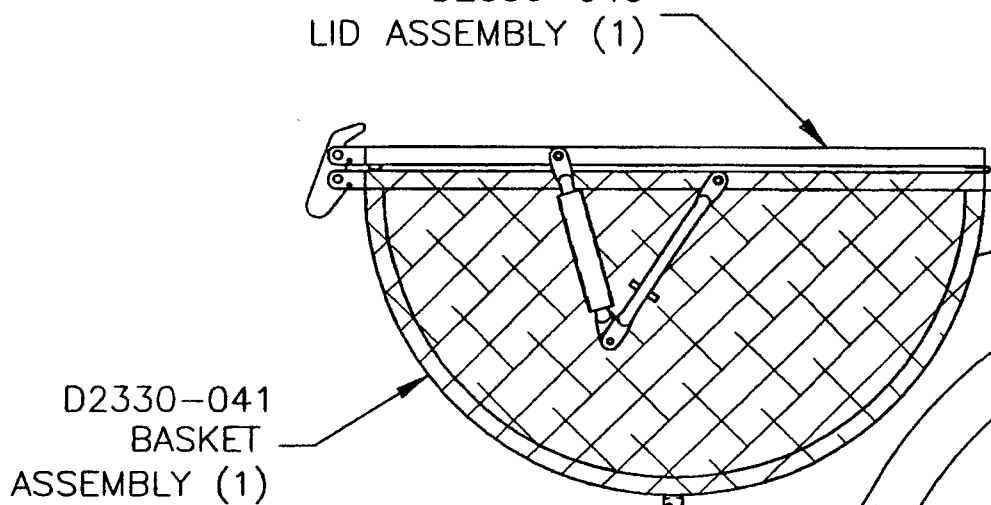
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CHECKED <del>KE</del>	APPROVED <del>CP</del>	DRAWING NO. D206-540	REV. H SHEET 5 OF 8
DATE 99.12.02	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



**DART**



AN4-21A BOLT (1)  
AN960JD416 WASHER (1)  
D2525 SPACER KIT\* (1)  
D2526 BUSHING (1)  
MS21042L4 NUT (1)  
(2 PLACES)  
\*USE D2525 SPACER KIT  
TO LINE-UP D2749  
STRUTS WITH SADDLE

D2748 CLEVIS\*\* (1)  
AN4-12A BOLT (1)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES)

**\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE**

SECTION A-A AND B-B

D206-540-013 (206 A/B) ONLY

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CHECKED	<del>JK</del>	APPROVED	<del>JK</del>	DRAWING NO.	REV. H
DATE	99.12.02			D206-540	SHEET 6 OF 8
				TITLE	SCALE
				UTILITY BASKET INSTALLATION	MTS

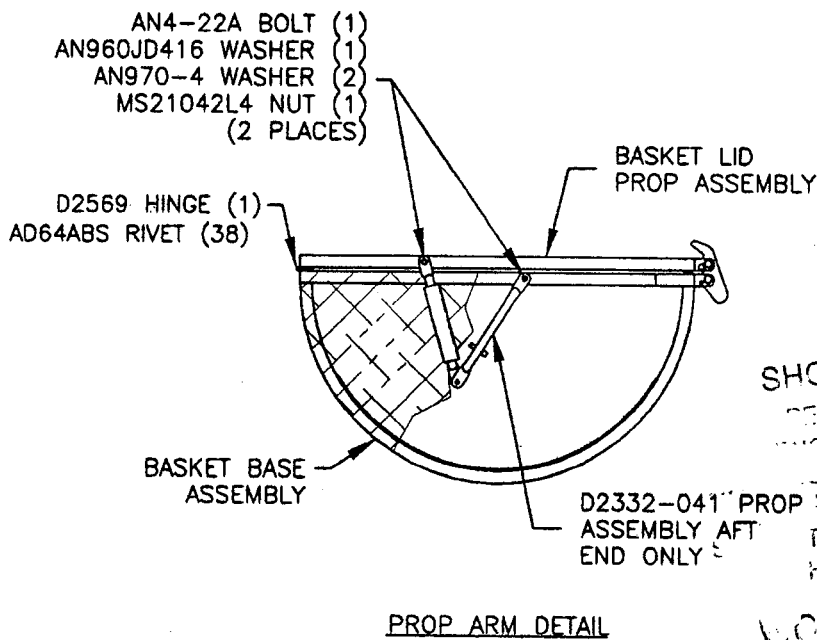
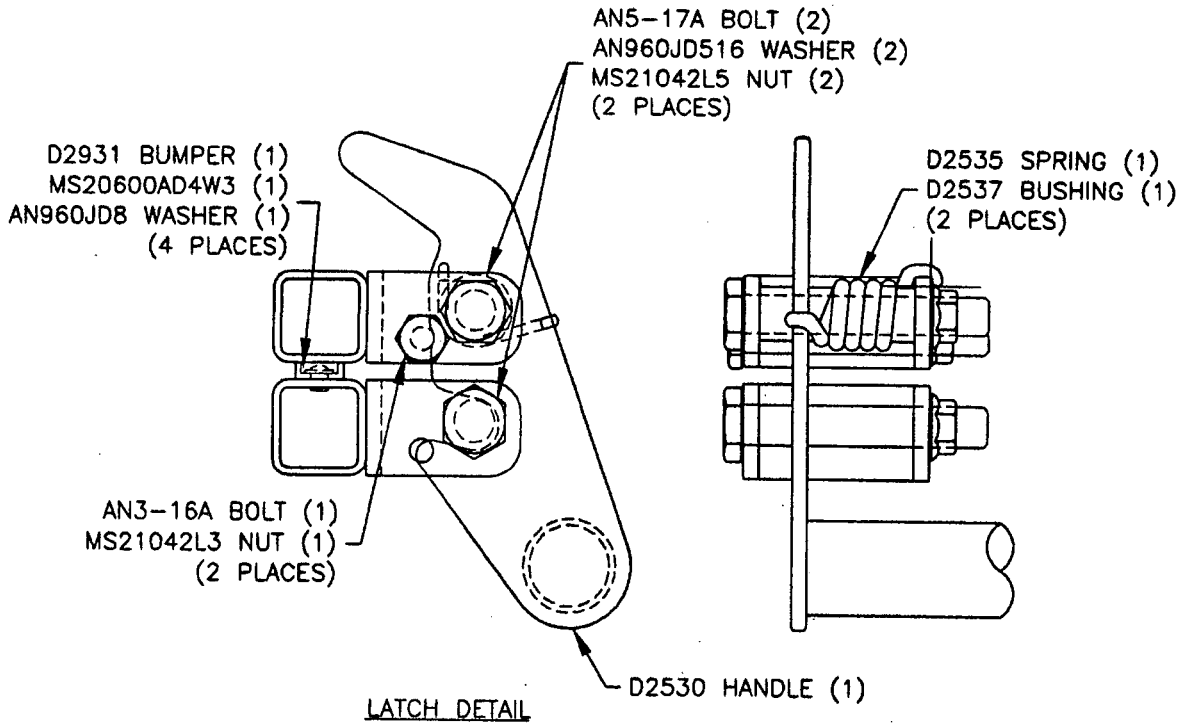
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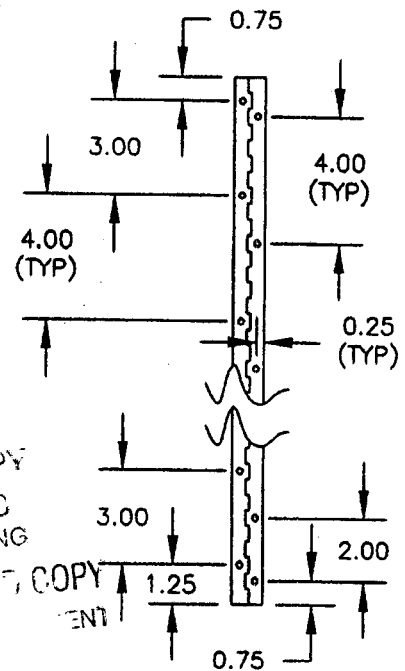


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-540	REV. H SHEET 8 OF 8
DATE 99.12.02		TITLE UTILITY BASKET INSTALLATION	SCALE NTS



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NO. 22087





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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9246	REV. A SHEET 1 OF 1
DATE 03.02.06		TITLE QUICK RELEASE KIT	SCALE NTS
A	03.02.06	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D206-540 REV. H

REF. CANADIAN STC: SH94-5

REF. FAA STC: SR00386NY

**PURPOSE: TO ALLOW SUBSTITUTION OF THE BASKET ATTACHMENT BOLTS WITH QUICK RELEASE PINS**

THE AN4-12, AN4-12A, & AN4-21A BOLTS MAY BE REPLACED WITH STAINLESS STEEL POSITIVE LOCKING QUICK RELEASE PINS WITH A MINIMUM DOUBLE SHEAR STRENGTH OF 2400 LBS AND 0.25 INCH DIAMETER

BOLT	MIN GRIP	POSSIBLE QUICK RELEASE PIN REPLACEMENT
AN4-12 AN4-12A	1.0"	AVIBANK: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S MS NUMBER: MS17984C410, MS17985C410, MS17986C410, MS17987C410 REID: BLRS-010, BLBS-010
AN4-21A	1.8"	AVIBANK: BLC4B20S, BLC4TA20S, BLC4R20S, BLC4LA20S MS NUMBER: MS17984C420, MS17985C420, MS17986C420, MS17987C420 REID: BLRS-030, BLBS-030

THE FOLLOWING OPTIONAL KITS ARE AVAILABLE FROM DART TO PROVIDE QUICK RELEASE CAPABILITY

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI9246-011	QUICK RELEASE KIT, 206 L/L1/L3/L4
	X	DSI9246-013	QUICK RELEASE KIT, 206 A/B
2	3	BLRS-010	QUICK RELEASE PIN (1" GRIP)
2	2	BLRS-030	QUICK RELEASE PIN (1.8" GRIP)

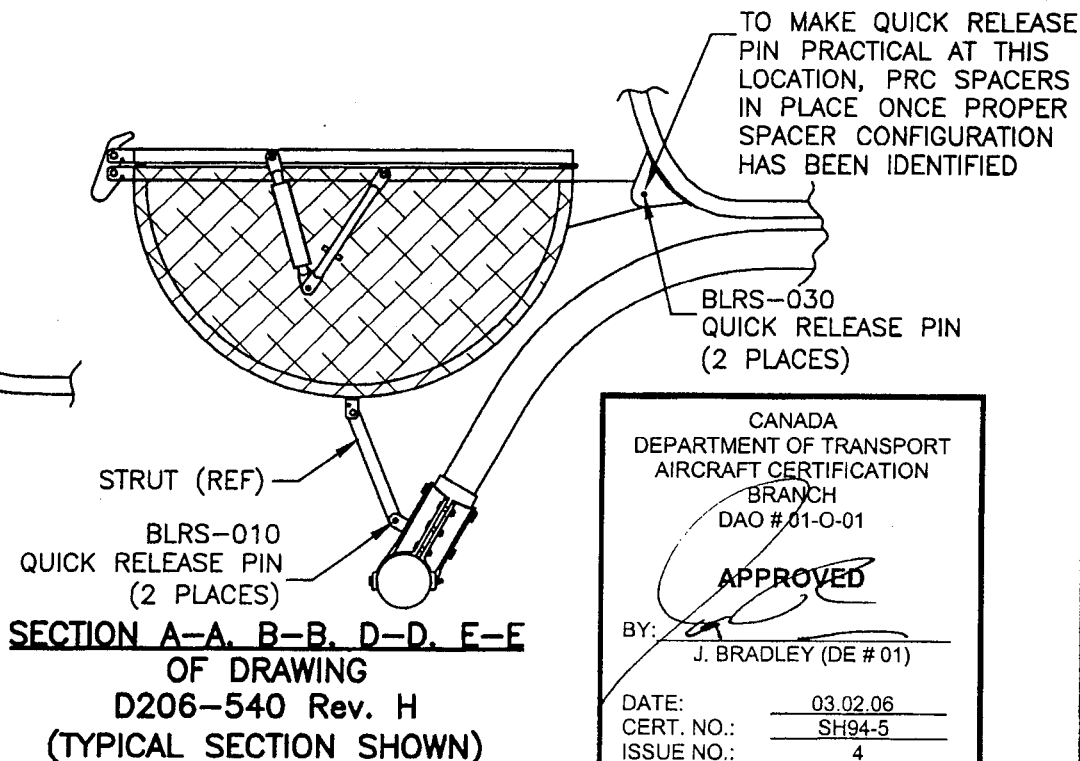
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NO. 22087

BLRS-010  
QUICK RELEASE PIN  
(1 PLACE)

D2814  
STRUT  
(REF)

**SECTION C-C  
OF DRAWING  
D206-540 Rev. H  
(206A/B ONLY)**



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-0-01	
APPROVED <i>[Signature]</i>	
BY:	J. BRADLEY (DE # 01)
DATE:	03.02.06
CERT. NO.:	SH94-5
ISSUE NO.:	4

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 24, 2005  
01:19 pm

Work Order No : 0022087  
Project Name : D206-540-013  
Project For : WK504  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*D206-540-013  
Description : Heli Utility Basket (B)  
Manufactured : Yes  
Amount Req'd : 1  
Amount Done : 0  
Start Date : 12-10-04  
Est Finish Date : 01-28-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

5104

DUPLICATE

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22087
<b>Description:</b> 206B Basket Base	<b>Part Number:</b>	D2330-041
<b>Drawing:</b> D2330 Rev. <sup>DI</sup> Pages 1,3,4 & 5	<b>Qty:</b>	1

RF 04.06.23

Step	Location	Procedure	By	Date	Qty
1	DC	Open Traveller <b>Dwg not required</b>	KJ	05.05.24	1
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: <u>B M 17627</u> Cut Qty. 4 D2235-1 from: Qty. 4 D3166-1 Batch: <u>B22924</u>	MA	05/05/31	1
3	WS	Drill hole in D2330-3 as per Dwg D2330	MA	05/05/31	1
4	WS	Deburr	MA	05/05/31	1
5	WS	Pick: Qty Part Number Description Batch 2 D2253-1 Gusset <u>B12412</u> 1 D2012-107 Clevis <u>B23031</u> 1 D2327-3 Bushing <u>B22026</u> 1 D2581 Mounting Chancel <u>A22852</u> 2 D2254 Lug <u>B20535</u> 30 sf M304EX0.75-16F Expanded Metal <u>M17452</u>	MA	05.06.02	1
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required	MA	05.06.02	1
7	QC9 & 6	Inspect Welding and Dimensions	2	05-06-02	1
8	WS	Take Traveller D206-540-013 to KP	MM	05.06.02	1
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3	MM FC	05.06.03	1
10	QC3	Inspect Powder Coat	MM	05.06.03	1
11	FP	To Miscellaneous Cell for Assembly	MM	05.06.03	1

RF 02/07/10  
make 1 x D2254  
by hand B6358

Rev	Date	Change	Revised By	Approved
B	94.12.03			JB
C	99.09.17	Re-format (was lpp-341B)	EC	
D	99.12.14	Re-format, Added Clevis to pick list	EC	
E	00.02.03	Re-format, Added Rib to pick list	EC	
F	00.06.26	Removed P/O for powder coat	EC	
G	02.07.23	Re-format added D3166-1; Modify Step 1	KJ	
H	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	

RELEASED  
02/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

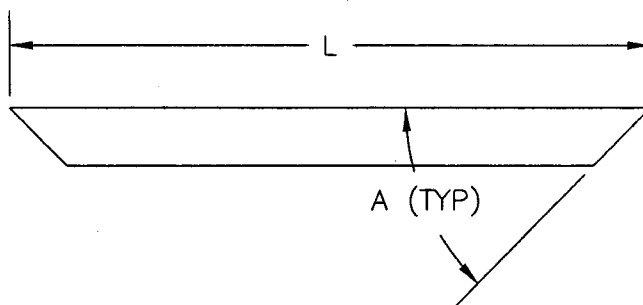


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. D SHEET 1 OF 5
DATE 99.09.14		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
DI	<i>4.01.15</i>	ADD MEMBERS TO LID FRAME	

RELEASED  
99.10.12 KE

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
2	2	D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
2		D2253	LUG		
2		D2254	GUSSET		
1	1	D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

MATERIAL: 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3  
WELD PER DART QSI 004

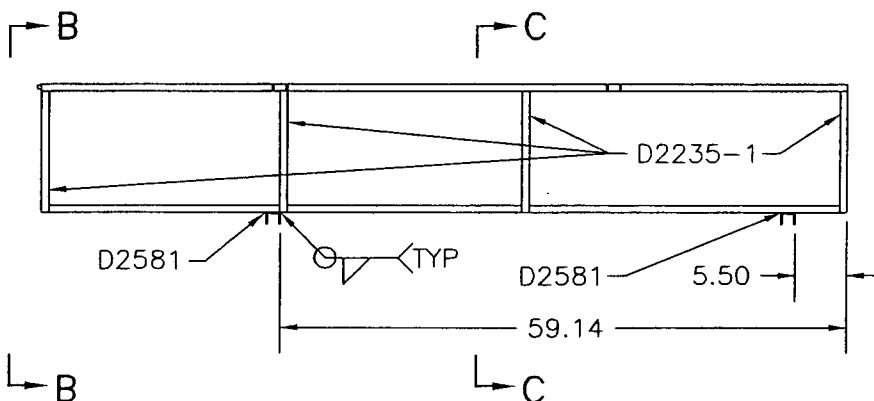
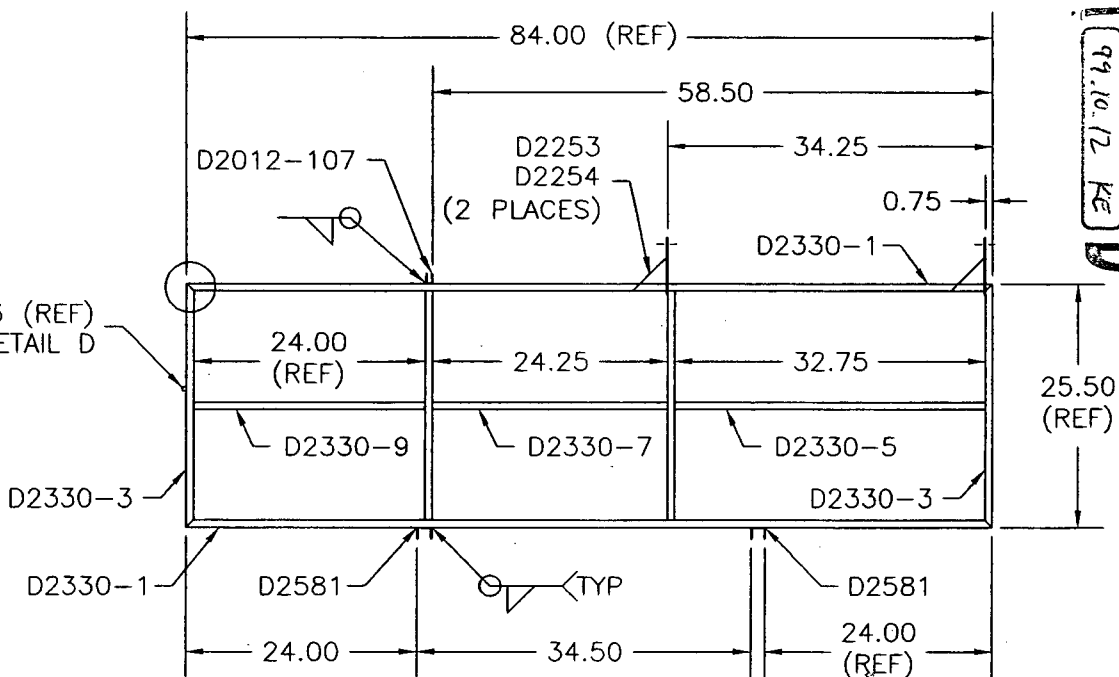
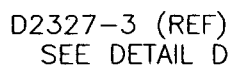
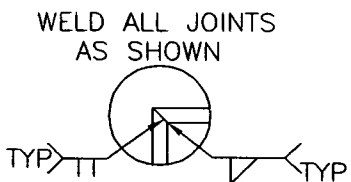


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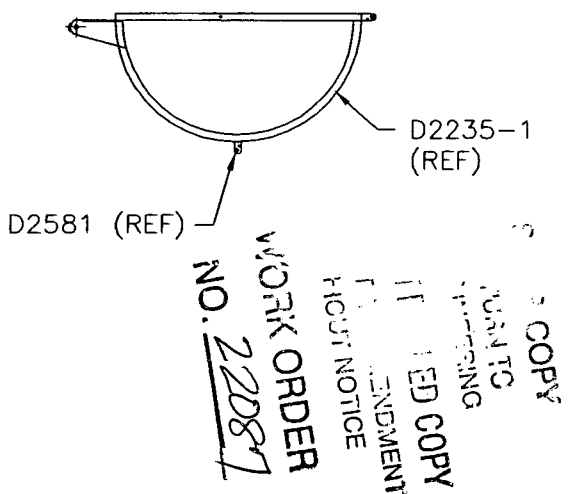
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CHECKED	TH	APPROVED	[Signature]	DRAWING NO.	REV. D
				D2330	SHEET 3 OF 5
DATE				TITLE	SCALE
99.09.14				BASKET ASSEMBLY (206B)	NTS



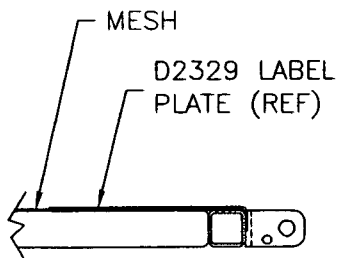
D2330-041 BASKET FRAME



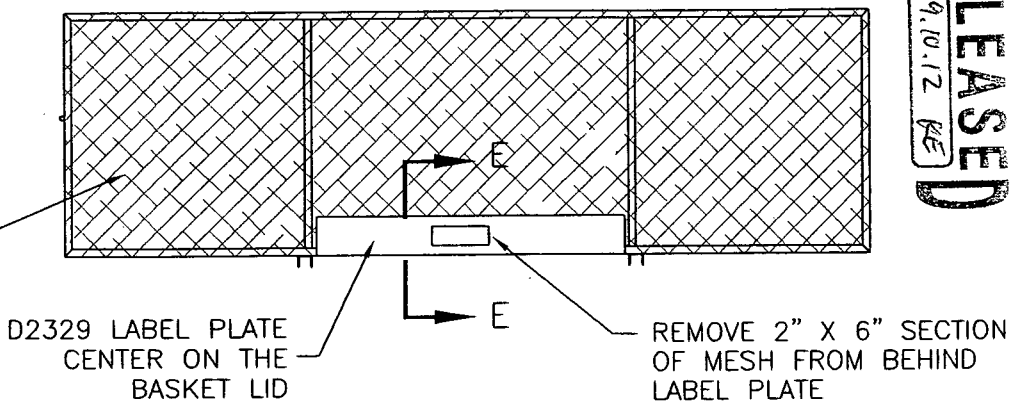


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DATE 99.09.14		D2330	SHEET 4 OF 5	
		TITLE	SCALE	
		BASKET ASSEMBLY (206B)	NIS	

RELEASED  
99.10.12 KE

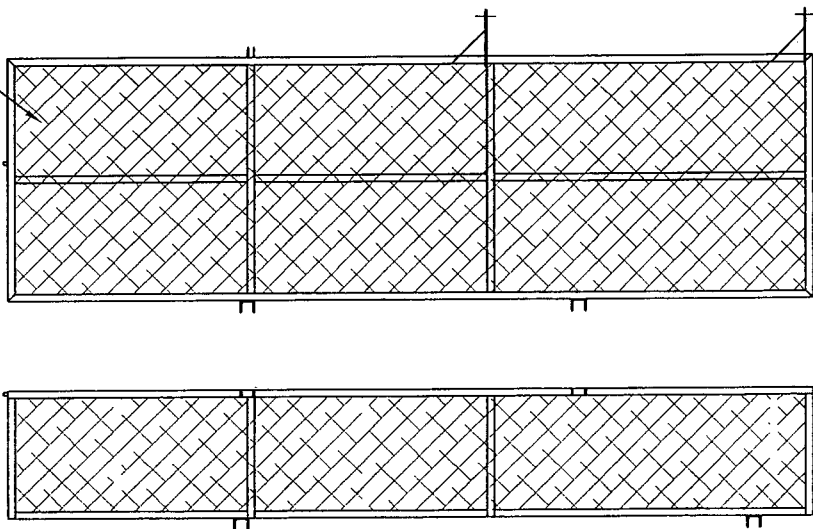


SECTION E-E

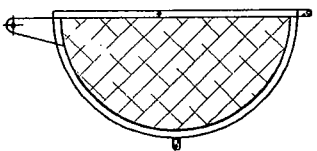


D2330-043 LID ASSEMBLY

SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME



D2330-041 BASKET ASSEMBLY



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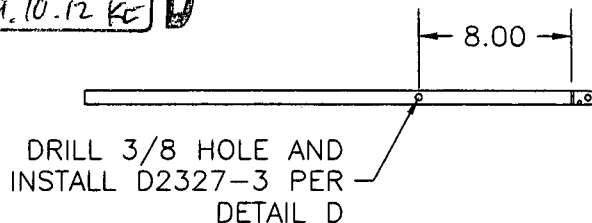
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NO. 22087



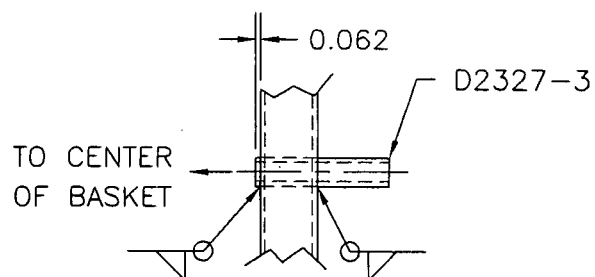


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. D SHEET 5 OF 5
DATE 99.09.14		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

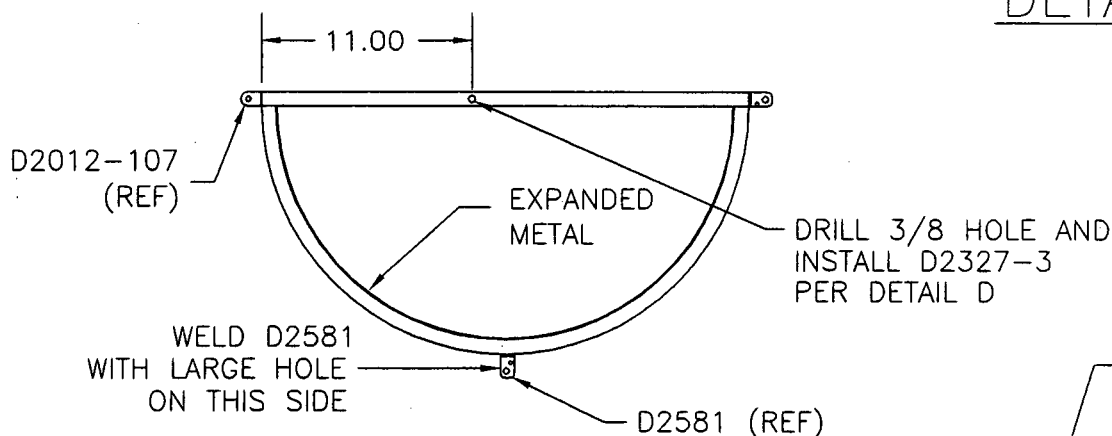
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99.10.12 KE



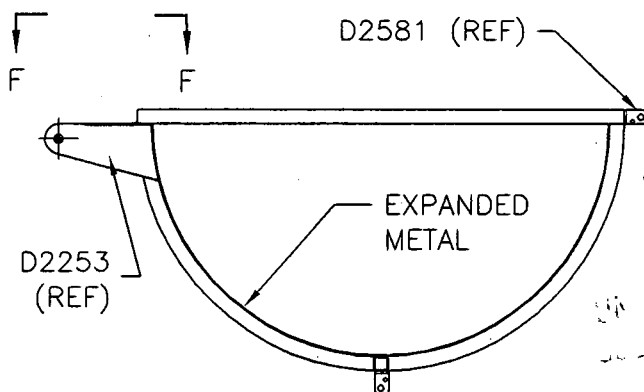
VIEW A-A



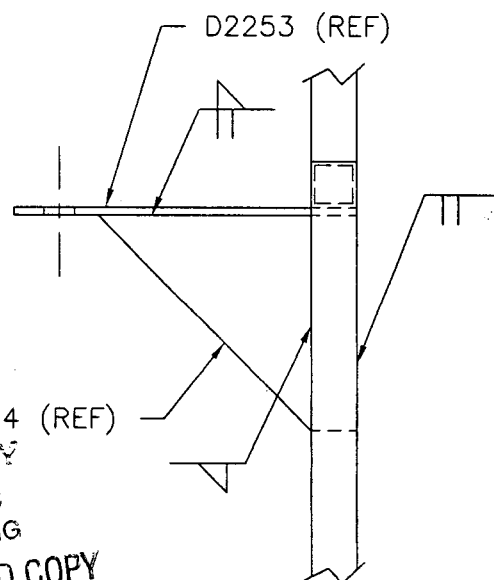
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VIEW B-B



VIEW C-C



VIEW F-F

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WORK ORDER  
NO. 22087

5/04

DUPLICATE

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22087
<b>Description:</b> 206B Basket Lid	<b>Part Number:</b>	D2330-043
DI		
<b>Drawing:</b> D2330 Rev. <del>D</del> Pages 1,2,4, & 5	<b>Qty:</b>	1

Step	Location	Procedure	By	Date	Qty
1	DC	Open Traveller <b>Dwg not required</b>	PA	05.05.24	1
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2330 Material: 304/316 SS tube .060" wall Batch 117627	MA	05/05/31	1
3	WS	Drill hole in D2330-3 as per Dwg D2330	MA	05/05/31	1
4	WS	Deburr	MA	05/05/31	1
5	WS	Pick: Qty Part Number Description Batch 1 D2329 Label plate 011637 1 D2327-3 Bushing B22026 2 D2581 Mounting Chanel B22852 18 sf M304EX0.75-16F Expanded Metal H11453	PD	05-06-02	1
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required	PD	05-06-02	1
7	QC9 & 6	Inspect Welding and Dimensions	Q	05-06-02	1
8	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3	MF	05-06-03	1
9	QC3	Inspect Powder Coat	MF	05-06-03	1
10	FP	To GA Cell for Assembly	MF	05-06-03	1

Rev	Date	Change	Revised By	Approved
B	94.12.03			JB
C	99.09.20	Re-format (was lpp-341B)	EC	
D	99.12.14	Re-format, removed step 14,15	EC	
E	00.06.26	Removed P/O for powder coat	EC	
F	02.07.23	Re-format, removed inspect level 5, added level 6	KJ	
G	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	

RELEASED  
02/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

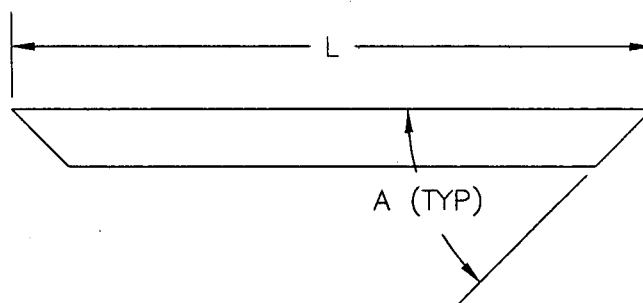


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. D SHEET 1 OF 5
DATE 99.09.14		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
DI	<i>[Signature]</i> 04.01.15	ADD MEMBERS TO LID FRAME	

RELEASED  
09.10.12 KE

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
2	2	D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
2		D2253	LUG		
2		D2254	GUSSET		
1	1	D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

MATERIAL: 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3  
WELD PER DART QSI 004



CUT SIZE DETAIL

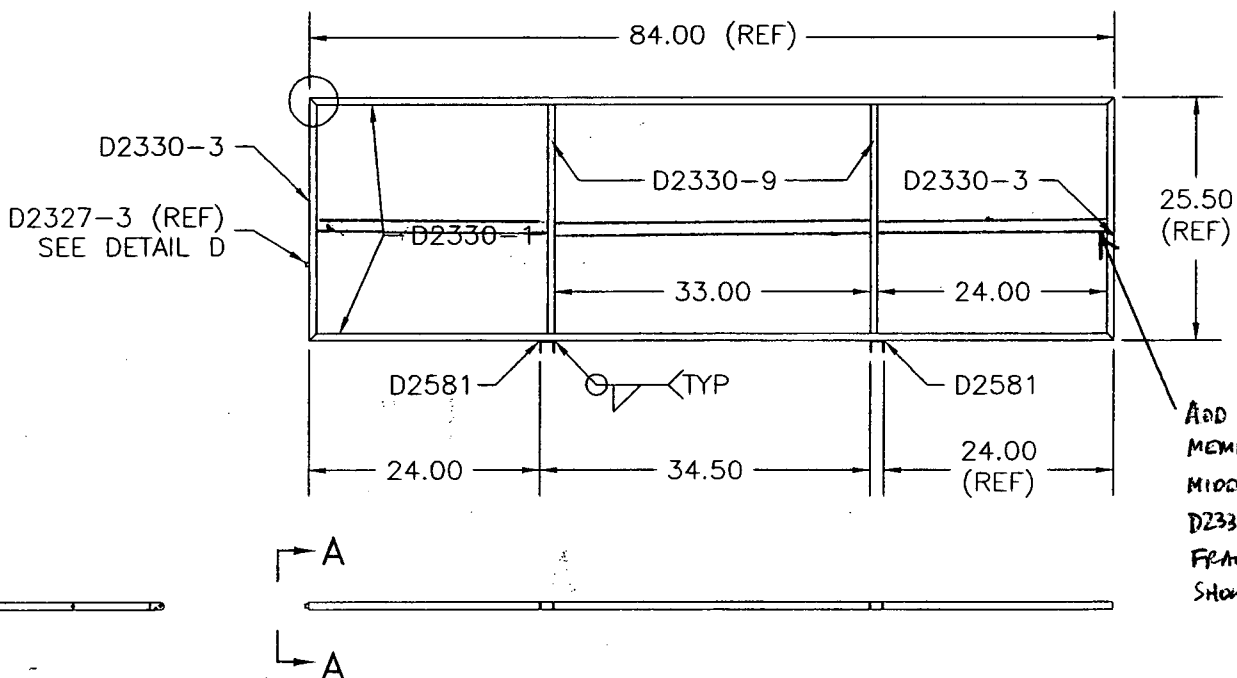
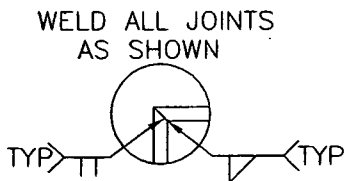
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NO. 22087



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DATE	99.09.14	TITLE	D2330	SHEET 2 OF 5
			BASKET ASSEMBLY (206B)	SCALE NTS

RELEASED  
99.10.12 KE



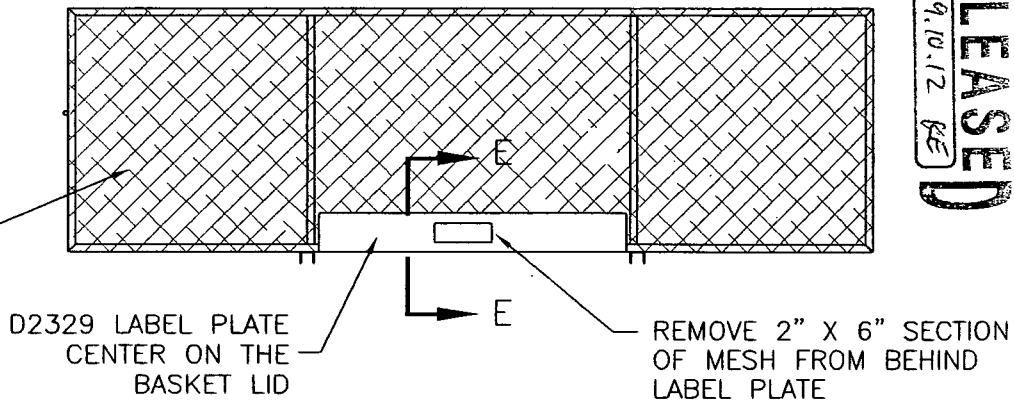
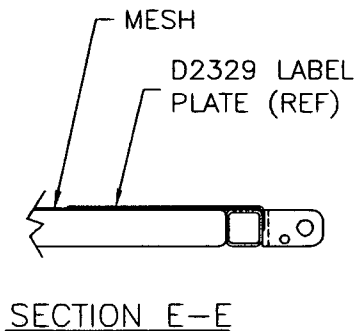
D2330-043 LID FRAME

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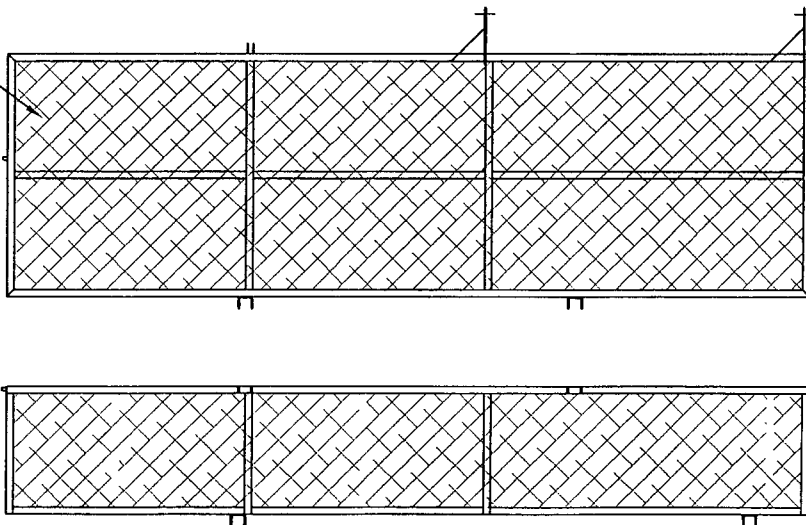
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CHECKED	APPROVED	DRAWING NO.	SHEET 4 OF 5
DATE		TITLE	SCALE
99.09.14		BASKET ASSEMBLY (206B)	NTS

RELEASED  
99.10.12 KE



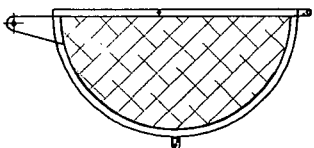
D2330-043 LID ASSEMBLY

SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME



D2330-041 BASKET ASSEMBLY

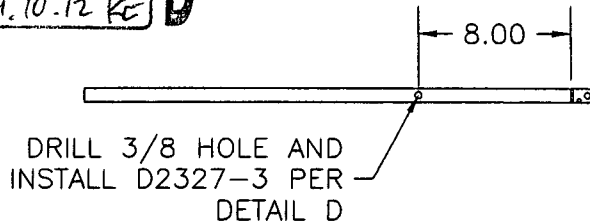
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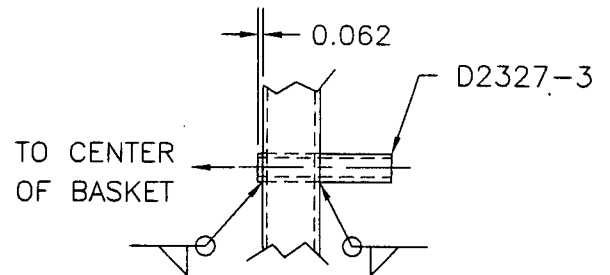


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CHECKED <i>TH</i>	APPROVED <i>KE</i>	DRAWING NO. D2330	REV. D SHEET 5 OF 5
DATE 99.09.14		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

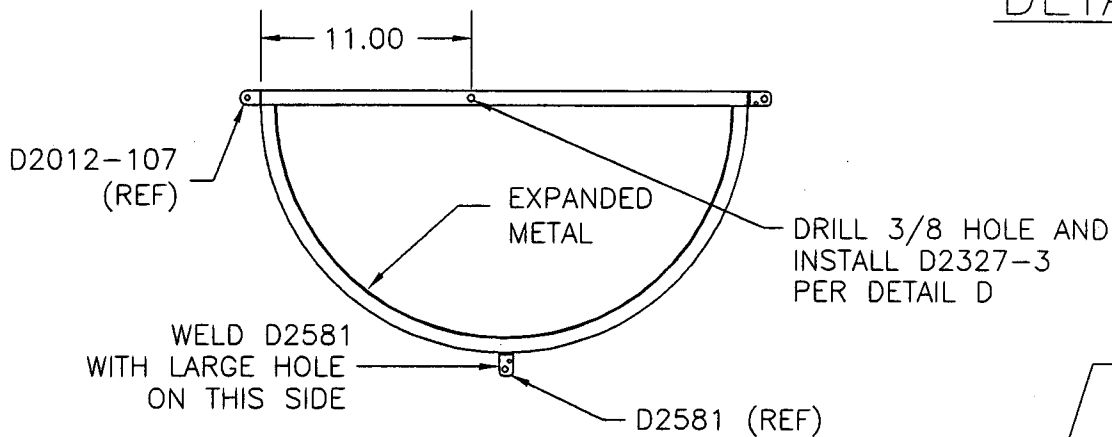
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99.10.12 KE



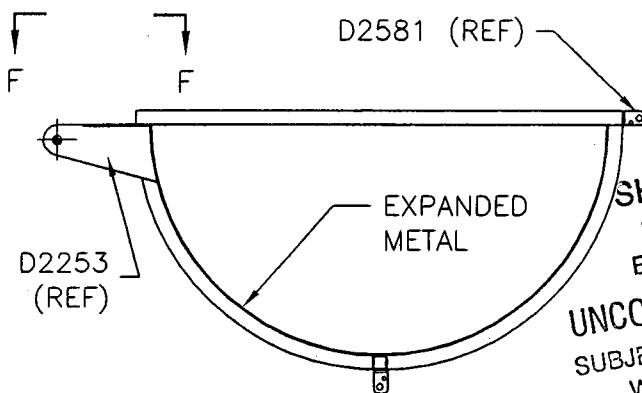
VIEW A-A



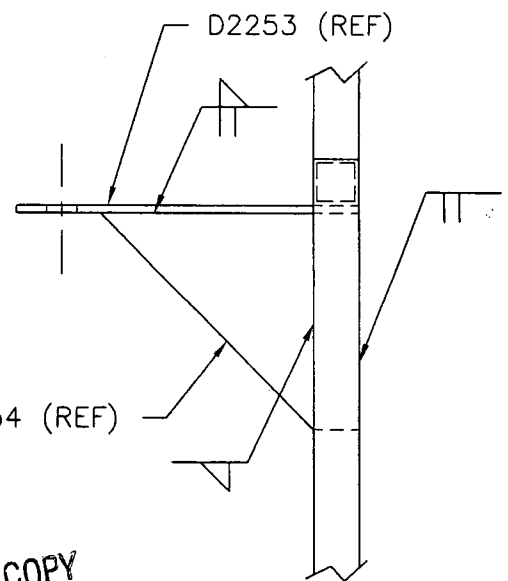
DETAIL D



VIEW B-B



VIEW C-C



VIEW F-F

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**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D206-540</b>	REV. 1 SHEET 1 OF 8
DATE <b>05.11.10</b>		TITLE <b>UTILITY BASKET INSTALLATION</b>	SCALE NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	
I	05.11.10	REPLACED PIANO HINGE SYSTEM	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	<del>D2258-470</del>	PLACARD <i>D2251-170</i>
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
16	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

\*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

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*REFERENCE ONLY*





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DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

## WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-540-011	70 lb	40.0 in	2800 in-lb	111.0 in	7770 in-lb
206 L Series Basket Installation	31.8 kg	1.0 m	31.8 m-kg	2.8 m	89.0 m-kg
D206-540-013	50 lb	40.0 in	2000 in-lb	99.0 in	4950 in-lb
206 A/B Series Basket Installation	22.7 kg	1.0 m	22.7 m-kg	2.5 m	56.8 m-kg

## GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

### WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

### CONTINUING AIRWORTHINESS

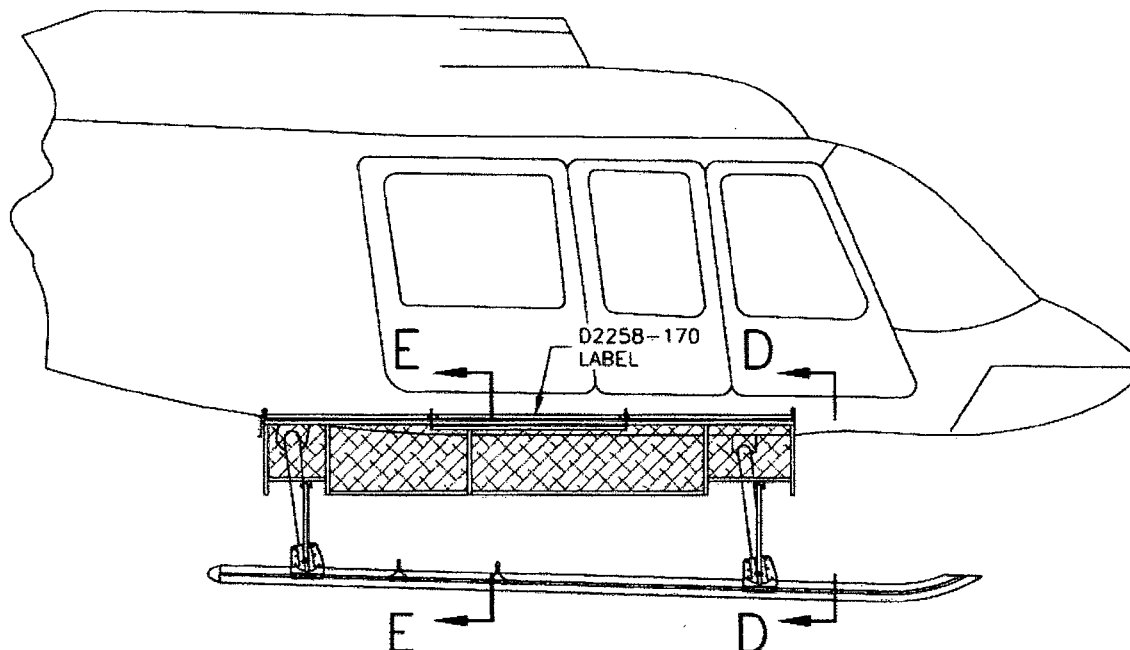
This installation should be maintained in accordance with the Maintenance Manual Supplement **MMS-D206-540**.

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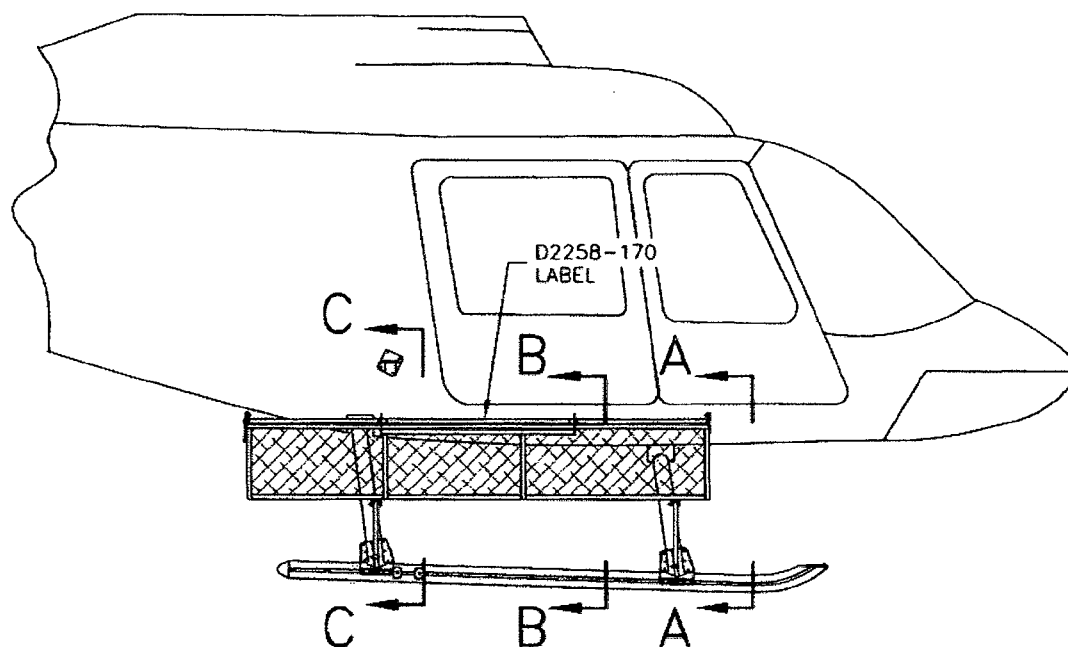
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



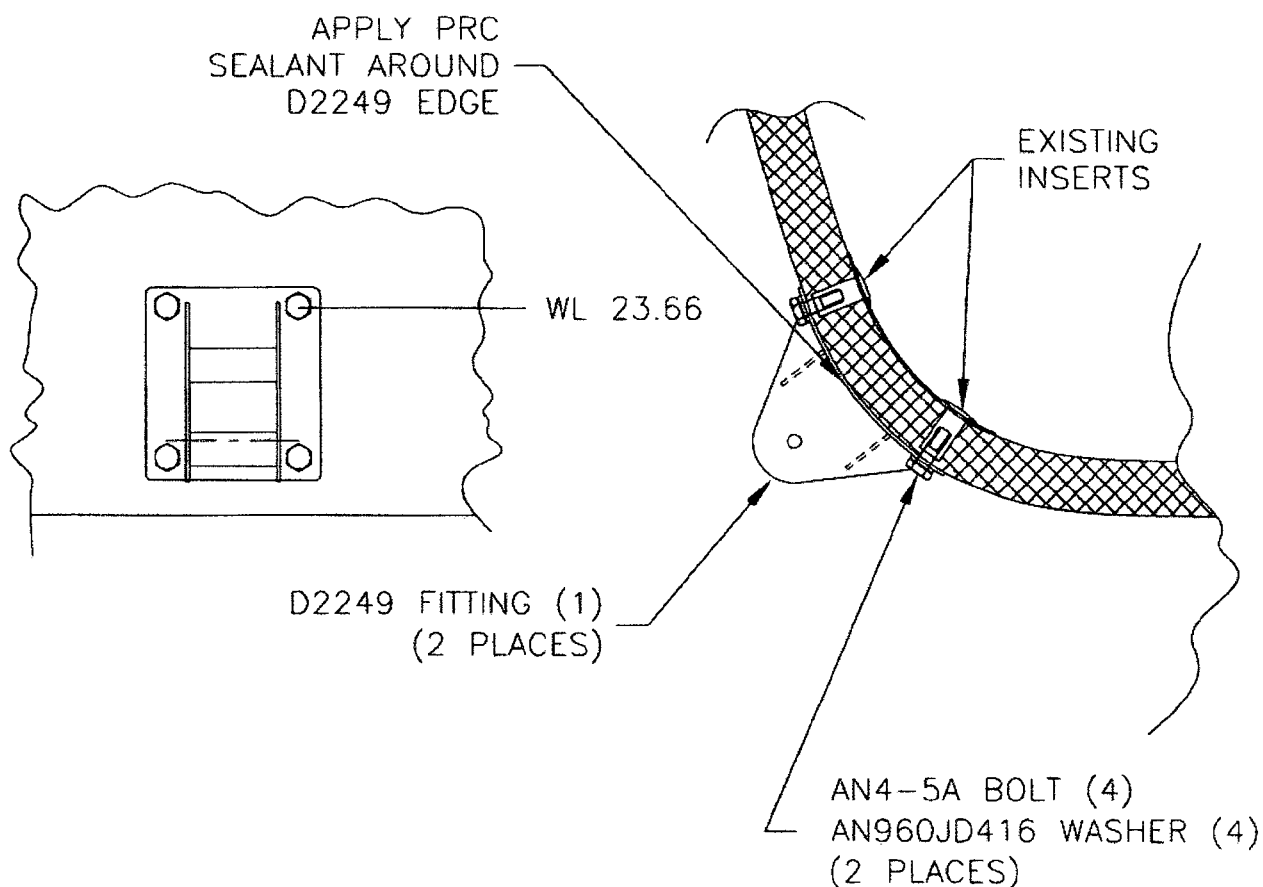
D206-540-013 206A/B BASKET INSTALLATION

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DATE	05.11.10			TITLE UTILITY BASKET INSTALLATION	SCALE NTS

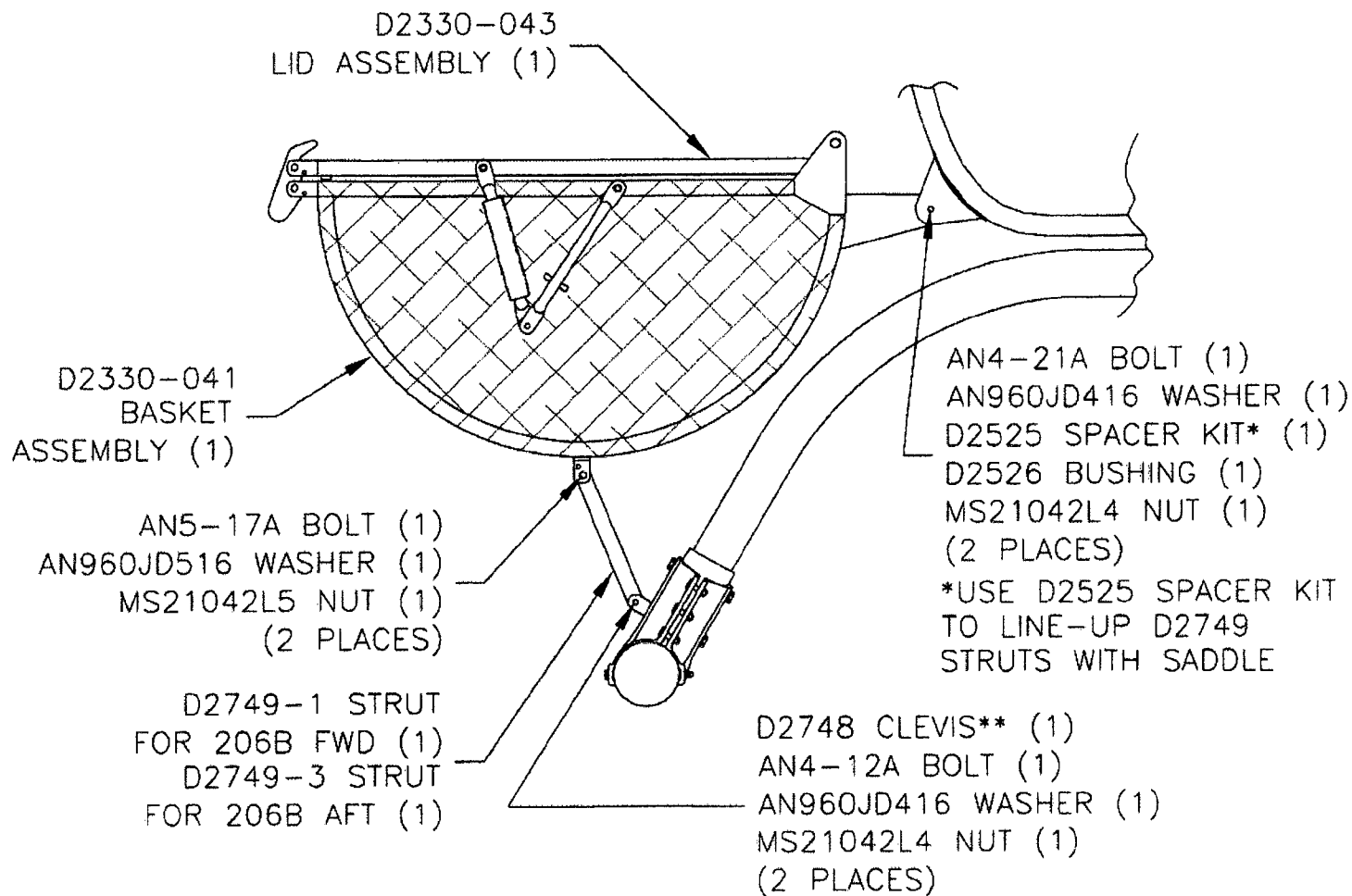


BRACKET DETAIL

REPLACE 206-031-370-6  
AND 206-031-370-8 STEPS AS  
REQUIRED WITH D2249 FITTINGS.  
REFER TO SERVICE INSTRUCTION  
BHT-206-SI-22

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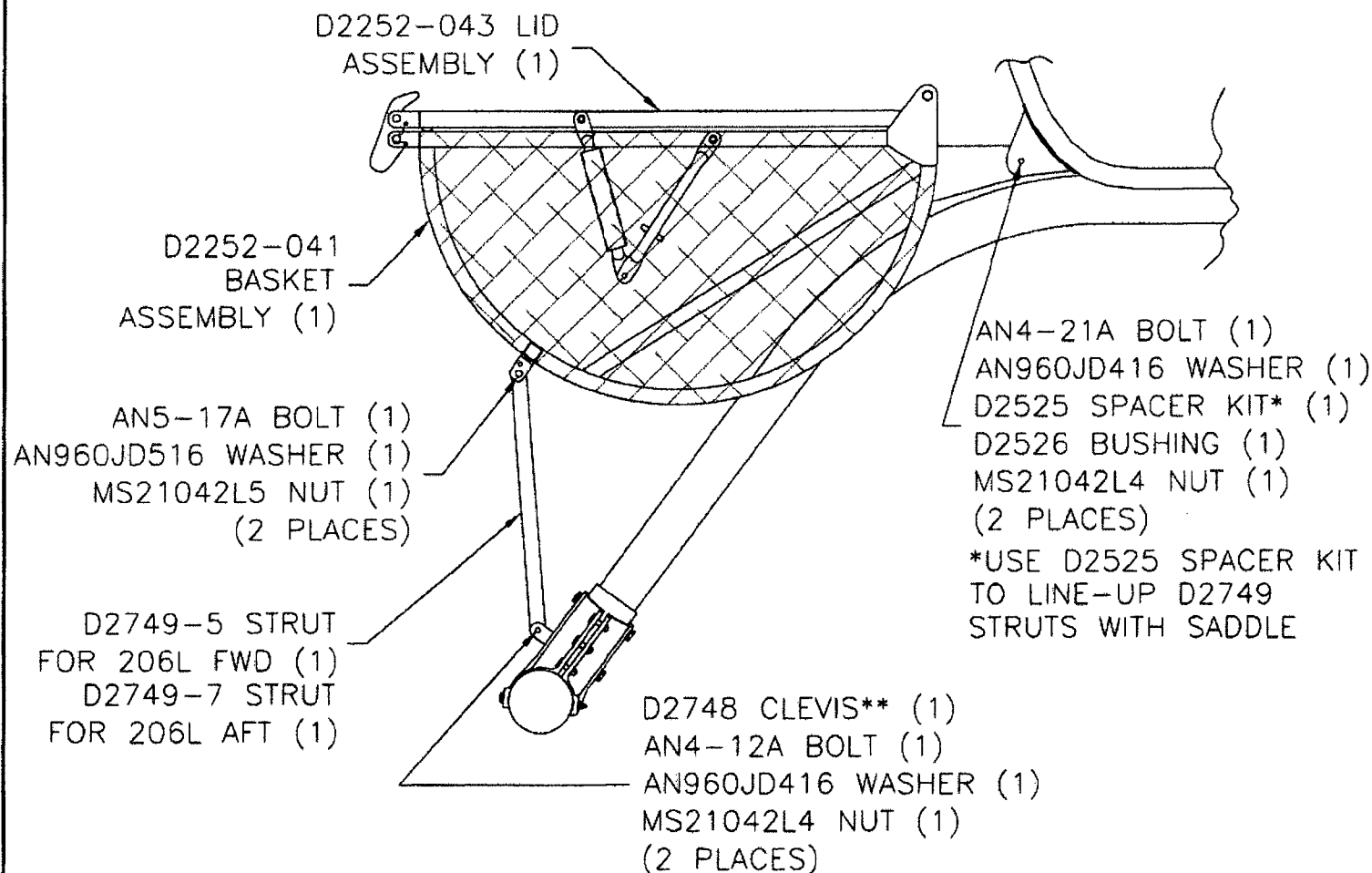


\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748  
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

SECTION A-A AND B-B  
D206-540-013 (206 A/B) ONLY

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		D206-540
DATE	TITLE	SHEET 6 OF 8
05.11.10	UTILITY BASKET INSTALLATION	SCALE
		NTS

**DART**



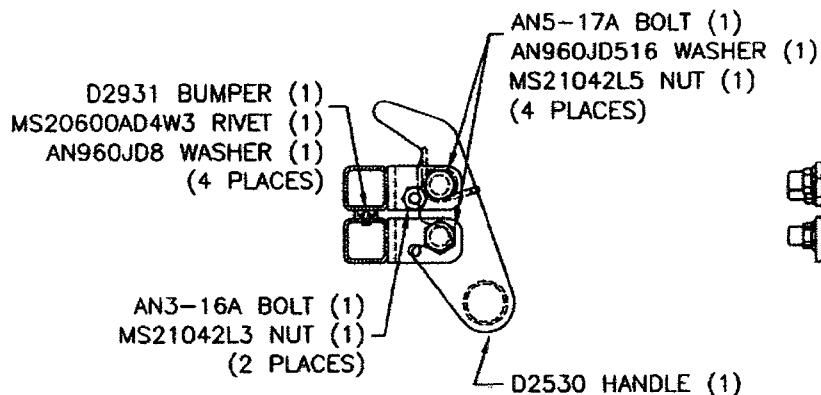
\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

**SECTION D-D AND E-E**  
**D206-540-011 (206 L/L1/L3/L4) ONLY**

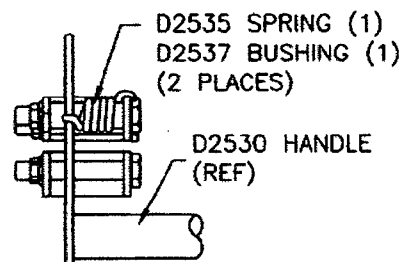
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DATE	TITLE	SHEET 7 OF 8
05.11.10	UTILITY BASKET INSTALLATION	SCALE
		NTS



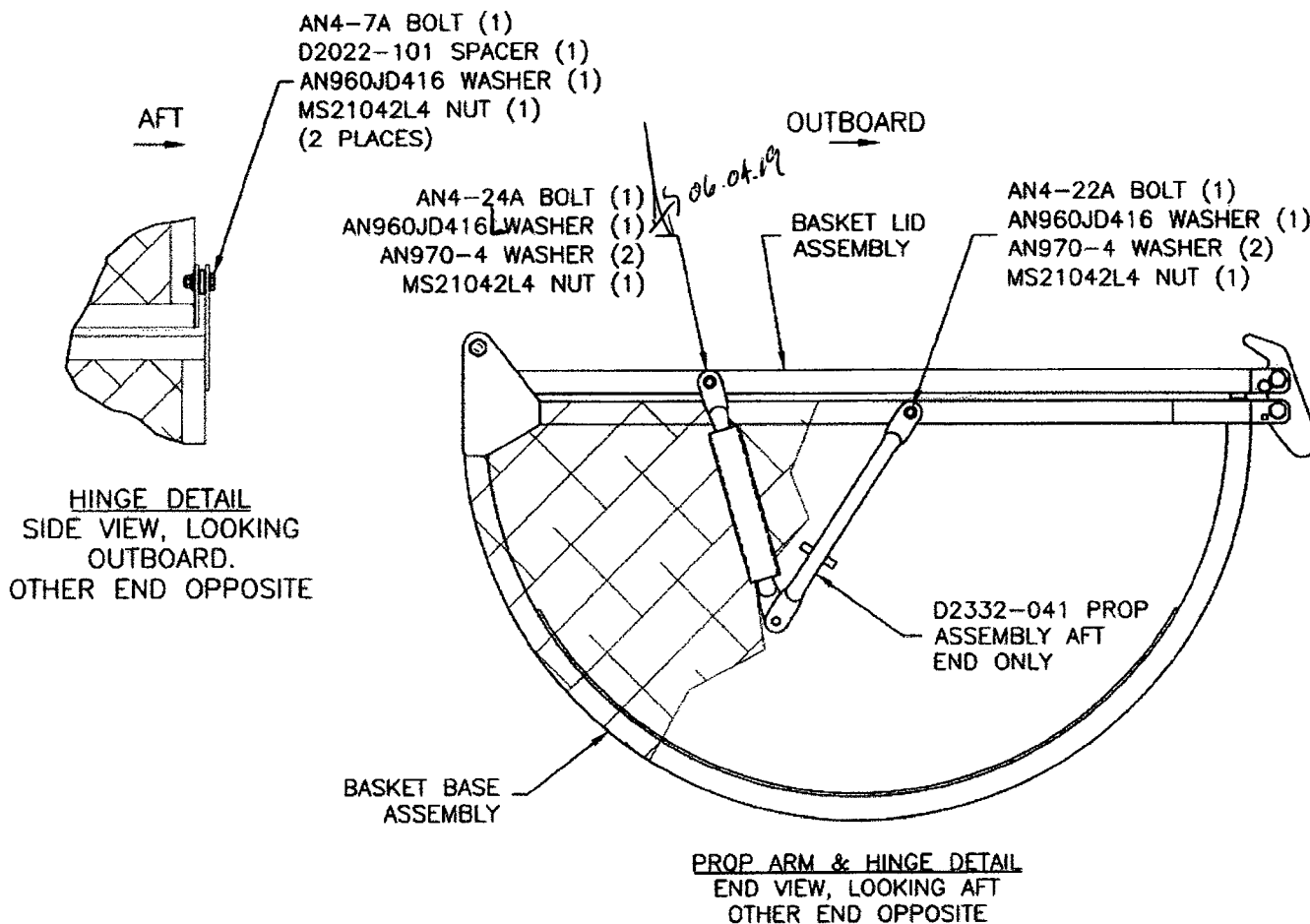
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DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS



LATCH DETAIL



SPRING DETAIL



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